

## Introduction of FEEDEX\* K spot feeding for DISA cast parts



### KNOWLEDGE & PARTNERSHIP

#### THE CHALLENGE

Converting a ductile iron casting which requires spot feeding, from a horizontal greensand moulding line to a vertically parted moulding line.

#### FOUNDRY: DÖKTAŞ DÖKÜMCÜLÜK

DÖKTAŞ is the largest iron foundry in Turkey with a capacity of



ca. 150,000 tonnes per annum. The foundry was established in 1973 and has built a global reputation for the production of high-quality iron castings, serving the truck, light vehicle, construction and agricultural sectors. Today ca. 70% of their output is for export.

#### PARAMETER

|                          |  |
|--------------------------|--|
| <b>Alloy:</b>            | Ductile Iron<br>EN-GJS-500               |
| <b>Casting Weight:</b>   | 26.8 kg                                  |
| <b>Pouring Weight:</b>   | 53 kg                                    |
| <b>Pouring Time:</b>     | 15 s                                     |
| <b>Pouring Temp.:</b>    | 1400°C                                   |
| <b>Moulding Process:</b> | Vertically Parted<br>Automatic Greensand |

#### FOSECO PRODUCTS

- FEEDEX HD1 GK KWS 7/10/33MH
- SEDEX\* FILTER 50X50X22/10

## OUR SOLUTION

Through the introduction of FEEDEX K we enabled the foundry to successfully spot feed an isolated heavy section in the centre of the casting. This avoided the need to modify the casting geometry or the use of metal padding to create a feed path.

## KEY BENEFITS

- Cost reduction moving the casting successfully to a vertically parted moulding line
- Sound castings
- Reduced scrap rate

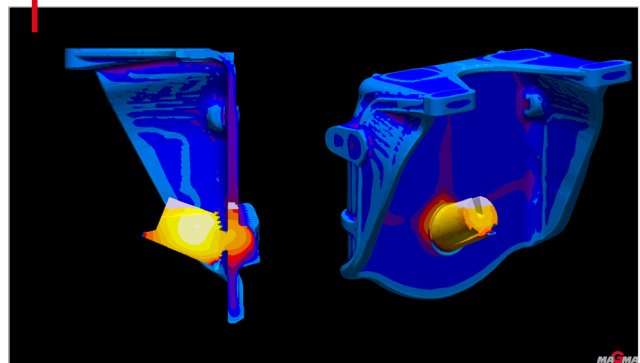
> LET'S LEARN MORE



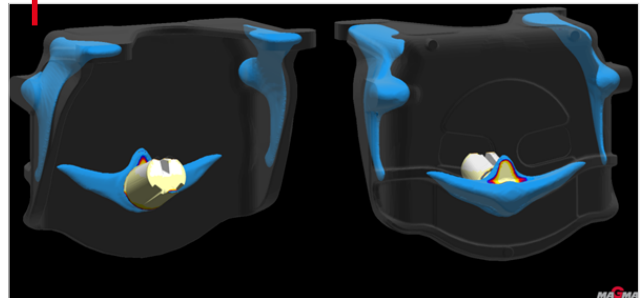
## THE OUTCOME

Reduced manufacturing cost through the successful transfer of the casting from a horizontal moulding line to a vertically parted moulding line. In addition, the use of FEEDEX K ensured a minimum contact area to the casting and reduced scrap due to shrinkage defects.

Magma Feedmod view



Magma Fraction liquid demonstrating aligned solidification



THINK BEYOND. SHAPE THE FUTURE.



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